

Work Order ID 130700

130700

Page 1

March-23-15 9:45:34 AM

Item ID: D2933-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH In, 206
 Start Date: 3/23/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 3/27/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-03-23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.08
 HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

15-03-29 4

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

15-03-29 4

120 0.00
120 QC1- Inspection performed by CMM
 QC Memo 0.00
 Quality Control

15-03-29 4 0

DAS
 44 15/03/29
 9-89

Work Order ID 130700

130700

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>4</u>	<u>6</u>		<u>15-3-30</u>
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.01				<u>4</u>		<u>15-3-30</u>	<u>[Signature]</u>
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3+5.1) per QSI005 4.3-Alum <u>M 129803</u> Memo START TIME: <u>11:05</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>12:05</u>	0.00 0.00				<u>4</u>	<u>6</u>	<u>15-3-21</u>	<u>234 989</u>

Work Order ID 130700

130700

Page 3

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Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Saddle RH In, 206
 Start Date: 3/23/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/27/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>(4)</u>			38 9-89 MAR 31 2015
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 39%</u> Memo	0.00 0.00				<u>4</u>		DAS 27 9-89	MAR 31 2015
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.01				<u>ML5</u>	<u>15-04-1</u>		<u>MS-4-1</u>

Picklist Print

March-23-15 9:45:33 AM

Page 1

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130700

Parent Item: D2933-2

D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 3/23/15

Required Date: 3/27/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	27.0000	1	4			

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

8

124413

8

MAT045

19

122672

7

125829

12

15-03-25

3
1

2

DART AEROSPACE LTD	Work Order: 130700
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

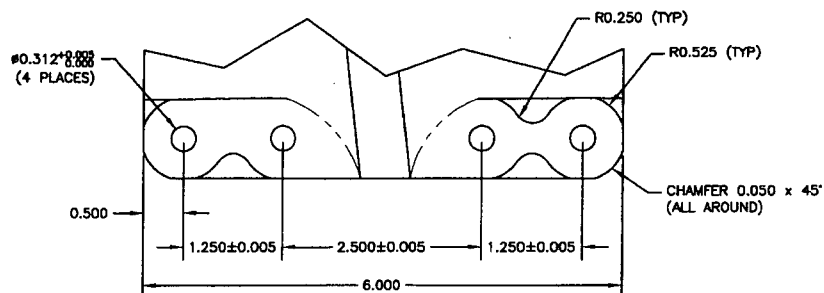
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.121		
B	0.100	0.140		.121	.123	.120	.122		
C	0.100	0.140		.120	.119	.119	.120		
D	0.210	0.230		.220	.221	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.122	.121	.121		
O	0.540	0.560		.548	.550	.548	.548		
P	0.490	0.510		.502	.501	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.493	2.492		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.140	.142	.138	.138		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.136	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.576	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J 15-03-29
Date:	

Audited by:	FR
Date:	15/03/29.

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

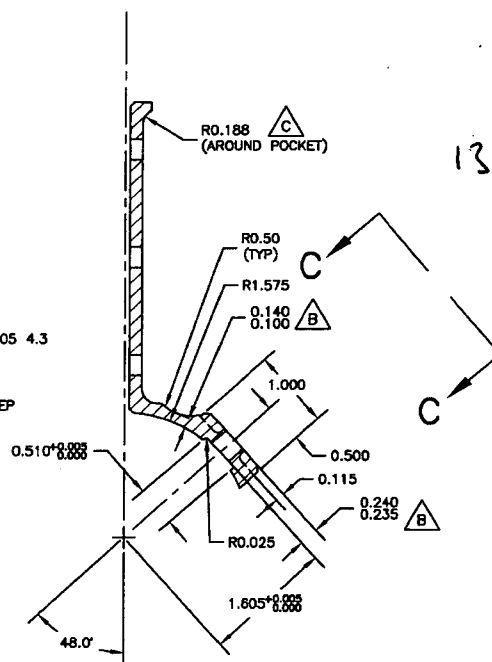


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

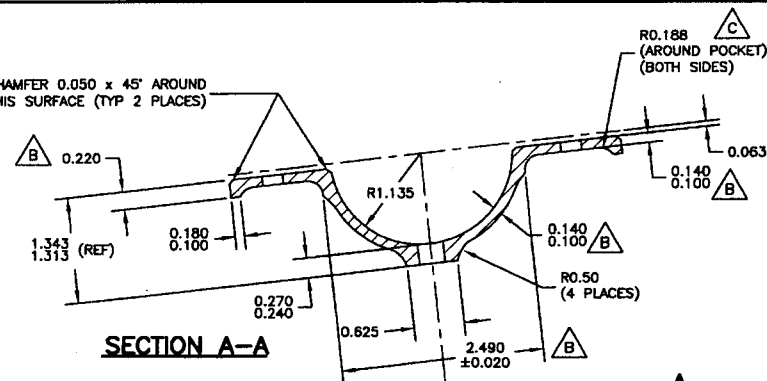
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

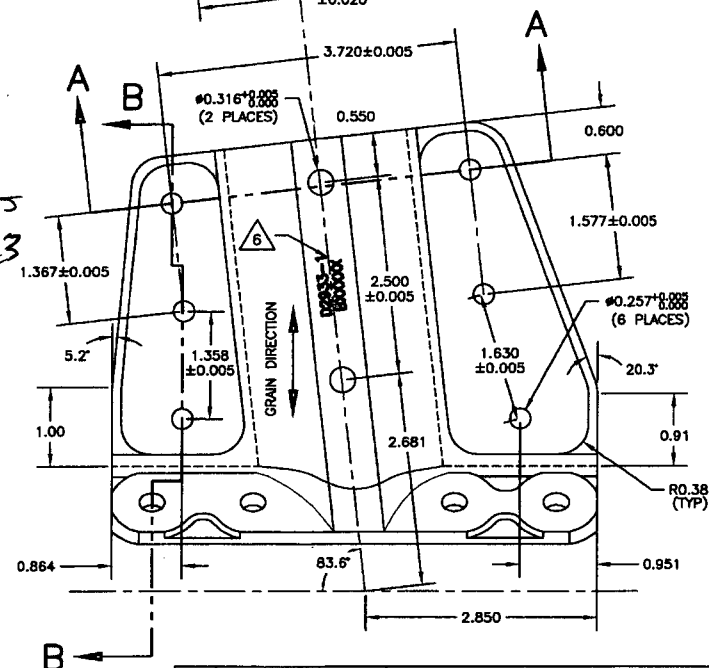


SECTION B-B

CHAMFER 0.050 x 45° AROUND
THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	41	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	DRAWING NO. D2933
		TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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BELLINGHAM, WA

07.02.12